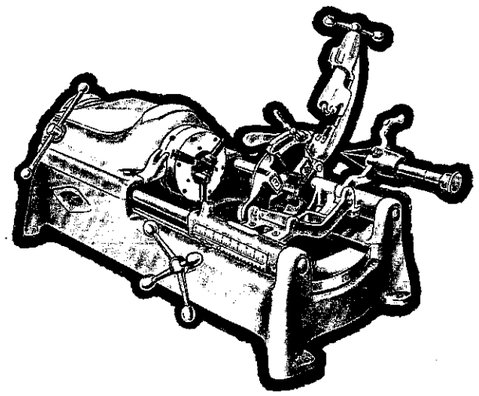
Important

For Your Own Safety
Before Assembling and Operating This Unit, Read This Operator's Manual Carefully and Completely. Learn The Operation, Applications and Potential Hazards Peculiar To This Unit.

RIDGID

500
Pipe and Bolt Threading Machine

Operator's Manual and Parts List



RIDGID

Pre-Tested Work Saver Tools

The Ridge Tool Company
400 Clark St., Elyria, Ohio 44035, U.S.A.

Form No. 500-M-167-R1

FOR YOUR FILE

PUBLICATIONS NOTICE

The Attached Literature Has Just Been Printed. **Date** 3/8/74

Reason 500 Manual

Bob Pesti -2

____ **New**

_X_ **Revision**

Type: _X_ **Parts** _X_ **Pictorial** _X_ **Copy**

Pages Affected Table of Contents, Guarantee, 3 (step 3), and relocated 13 through 22.

Signed R. Pesti

Additional copies of attached literature can be requested from The Ridge Tool Printing Department. Include literature Form No. with request.

For Your Own Safety

This unit is equipped with a Foot Switch which turns it on and off.

The switch on the side of the unit determines only the direction of chuck rotation.

Instructions and illustrations in the attached operator's manual are applicable, however, they do not include information on the Foot Switch.

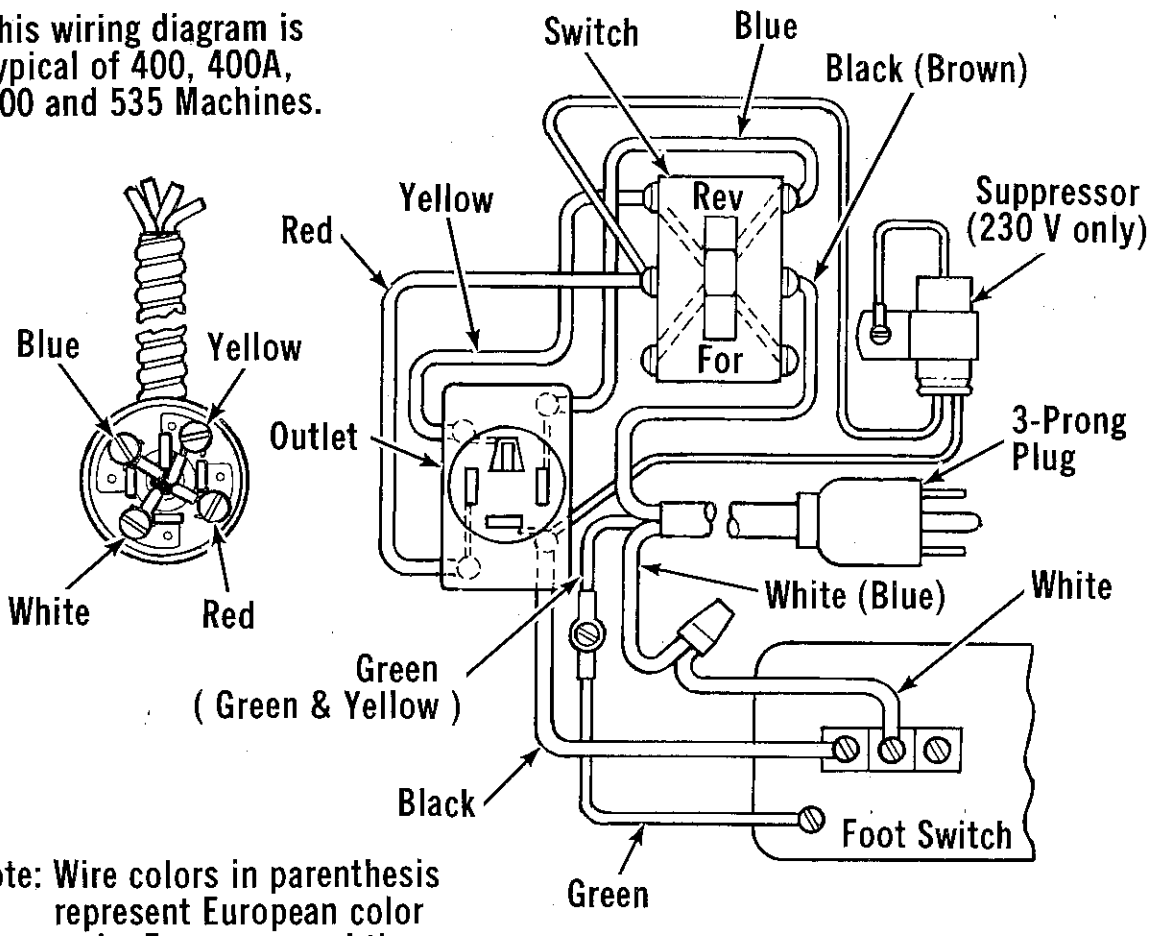
The Foot Switch is for your convenience and safety.

If your present RIDGID Power Drives or Pipe and Bolt Threading Machines are not equipped with Foot Switches, we recommend the RIDGID No. 301 Foot Switch. You will enjoy the convenience as well as the added safety.

This Wiring Diagram supersedes the present Wiring Diagram in this operator's manual.

This unit is wired for A.C. only.

Note: This wiring diagram is typical of 400, 400A, 500 and 535 Machines.



Note: Wire colors in parenthesis represent European color code. European cord the same except for plug.

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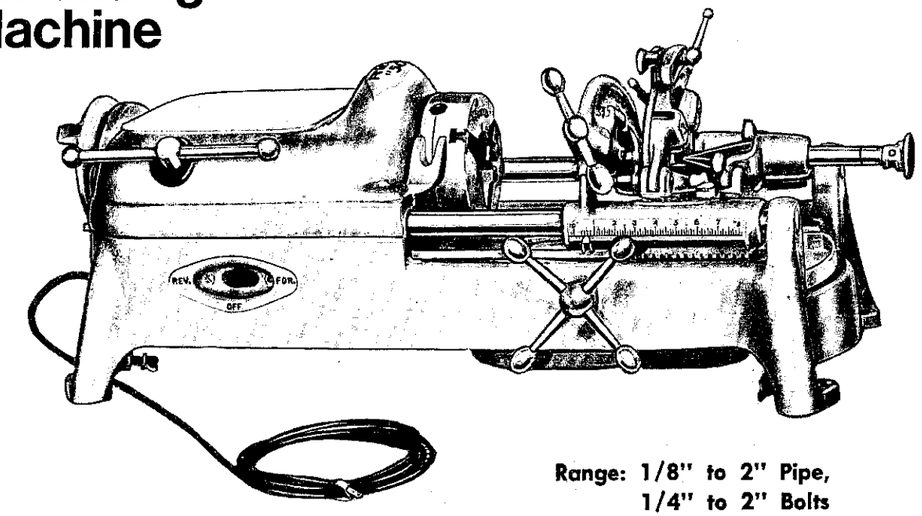
Form No. 500-M-167-R1

Printed in U.S.A.

RIDGID

500
Pipe and Bolt Threading Machine



Range: 1/8" to 2" Pipe, 1/4" to 2" Bolts

Pat. Nos. 2,748,716
2,768,550
2,916,749

Guarantee

All RIDGID Machines, Power Drives, and Hand Tools are guaranteed against defects in workmanship and material. This guarantee covers all RIDGID products except electric motors, which are guaranteed for six months from date of sale. NO OTHER GUARANTEE, WRITTEN OR ORAL, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, APPLIES. No employee, agent, dealer, or other person is authorized to give any guarantees on behalf of The Ridge Tool Company. Claims cannot be allowed until the questioned product has been received, freight prepaid, at our factory. Defective products will be repaired or replaced, at our option, at no charge to you. Such replacement or repair is the exclusive remedy available from Ridge. Ridge is not liable for damage of any sort, including incidental and consequential damages.

The Ridge Tool Company/Elyria, Ohio, U.S.A.

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Description and Specifications

Description

The RIDGID No. 500 Pipe and Bolt Threading Machine is an electric-motor-driven machine which centers and chucks the pipe, conduit and rod (bolt stock), and rotates it while threading, cutting, and reaming operations are performed. Left-hand or right-hand rotation can be selected by switch operation. Threading dies are mounted in Self-Opening or Quick-Opening Die Heads. An integral system is provided to flood the work with thread cutting oil during threading operations.

Specifications/Standard Equipment

Threading Capacity
Pipe ..... 1/8" through 2"
Bolt ..... 1/4" through 2"
Cutter No. 820 (Roll-type cutoff, self-centering, full floating)
Pipe Capacity ..... 1/8" through 2"
Bolt Capacity ..... 1/4" through 1"
or
No. 821 (Blade-type cutoff, self-centering, full floating)
Pipe Capacity ..... 1/2" through 2"
Dovetail-type cutoff and chamfering tool.
Reamer ..... Positive-locking, 5-flute cone, right hand, 1/8" through 2"
Chuck ..... RIDGID 3 Jaw Wrench-type
Rear Centering Device ..... Scroll operated, rotates with Chuck
Pump ..... Vane type
Switches ..... FOR-OFF-REV: Heavy-duty, toggle type, bump-proof mounted.
Motor ..... Universal type
Horsepower ..... 1/2 at 14000 rpm
Volts ..... 115v, single phase AC (25-60 Hz), or DC
230 available on request
Length ..... 41"
Width ..... 21"
Height ..... $14\frac{11}{16}$"
Weight with Standard Equipment (less die heads & dies) ..... 275 lbs.
Tools and materials supplied with machine
1 spare No. E-1032 Cutter Wheel
4 Allen wrenches (5/32, 3/16, 7/32, and 5/16)
2 gallons of RIDGID Nu-Clear Thread Cutting Oil
1 tube Lubricating Grease

Accessories

Die Heads

No. 815 Self-Opening Die Head (R.H. only)
Pipe Capacity: 1/8" through 2"; 4 sets of dies (1/8"), (1/4" and 3/8"), (1/2" and 3/4"), and (1" through 2").
Bolt Capacity: 1/4" through 2" bolt stock (one set of dies for each size).

Universal Quick-Opening Die Head (Specify R.H. or L.H.) Pipe Capacity: 1/8" through 2" pipe; 4 sets of dies (1/8"), (1/4" and 3/8"); (1/2" and 3/4"), and (1" through 2"). (No. 1/8" dies for L.H. die head)
Bolt Capacity: 1/4" through 2" bolt stock (one set of dies for each size). (No L.H. bolt dies are available for L.H. die head).

No. 515 Quick-Opening Die Head (R.H.)
Capacity: 1/8" through 3/4" pipe; 3 sets of dies (1/8"), (1/4" and 3/8"), (1/2" and 3/4").

No. 514 Quick-Opening Die Head (L.H.)
Capacity: 1/8" through 3/4" pipe; 3 sets of dies (1/8"), (1/4" and 3/8"), (1/2" and 3/4").

Mono Quick-Opening Die Heads
9 sizes, 1/8" through 2" pipe. Separate head and dies for each size (1/8"), (1/4"), (3/8"), (1/2"), (3/4"), (1"), (1 1/4"), (1 1/2"), and (2").

No. 500-B Quick-Opening 1/4" through 1" Bolt Die Head
R.H. or L.H. dies available. Separate dies for each size.

No. 500-B Quick-Opening 1 1/8" through 2" Bolt Die Head
R.H. and L.H. dies available. Separate dies for each size.

Die Head Racks
2 sizes—4U holds 4 heads.
6U holds 6 heads.

No. 819 Nipple Chuck (R.H. only)
Standard Range 1/2" through 2" pipe. 1/8", 1/4", 3/8" pipe adapters also available. 1/4" through 2" UNC and 1/4" through 1 1/2" UNF stud adapters available.

Stands
4 models available.

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Safety

1. **Know your machine.** Read the Operator's Manual carefully. Learn the operation, application, and limitations as well as the specific potential hazards peculiar to this machine.
2. **Avoid accidental starting.** Make sure switch is off (center position) before plugging in power cord.
3. **Ground the machine. For safety, this machine is equipped with a power cord having a three-prong plug for use on internally grounded electrical systems.** If electrical system is not grounded, ground machine in accordance with Article 250 of the National Electrical Code.
4. **Keep guards in place** and in working order.
5. **Remove adjusting keys and wrenches.** Form habit of checking to see that keys and adjusting wrenches are removed from machine before turning on machine.
6. **Support work.** Support long, heavy work from the floor with a pipe support.
7. **Secure work, machine and accessories.** Carefully tighten chuck (and rear centering device if work is sufficiently long) on work. Make sure machine, and stand if used, are stable. See instructions for threading pipe larger than 2", page 8.
8. **Wear proper apparel.** No loose clothing (unbuttoned jackets or loose sleeve cuffs) or jewelry to get caught in moving parts.
9. **Don't overreach.** Keep your proper footing and balance at all times. Be sure you can reach switch safely at all times. Do not reach across moving or rotating parts or material being worked on. Keep hands and loose tools away from moving elements.
10. **Maintain machine** in top condition. Use sharp cutting tools and keep machine clean for best and safest performance. Follow lubricating instructions.
11. **Keep work area clean.** Cluttered areas, benches, and slippery floors invite accidents.
12. **Avoid dangerous environment.** Don't use the machine in damp or wet locations. Keep work area well illuminated. Allow sufficient space to operate machine and accessories properly and for others to pass safely.
13. **Wear ear protection** if exposed to long periods of very noisy shop operations.
14. **Use safety glasses and footwear.**
15. **Keep visitors away.** All visitors should be kept a safe distance from work area.
16. **Don't force machine.** It will do the job better and be safer at the rate for which it was designed.
17. **Use recommended accessories.** Consult the Operator's Manual. Use of improper accessories may be hazardous.
18. **Disconnect power cord** before adjusting and servicing, and before changing accessories. Cord should be in good condition.

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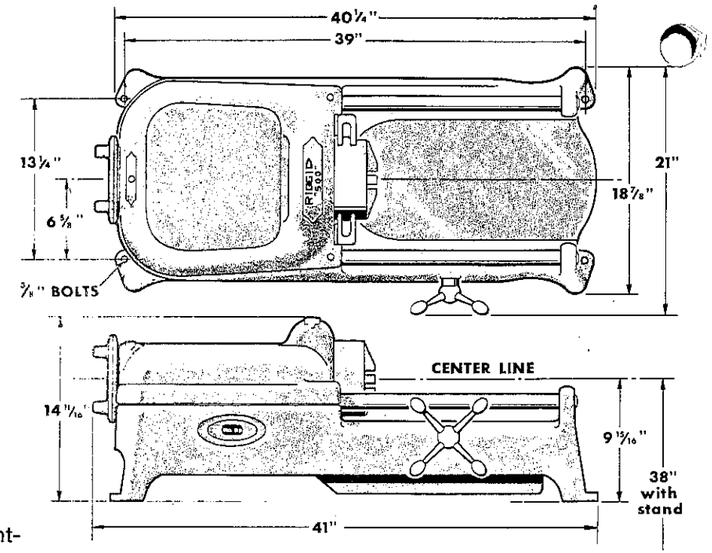
Dimensions, Assembly and Setup Instructions

The RIDGID No. 500 Pipe and Bolt Threading Machine dimensions are shown at right. The machine is designed to be mounted on an Open Wheel Stand, an Enclosed Wheel Stand, and Open Leg Stand, 4 Legs only, on a bench or on self-made legs. Assemble the machine to its stand as directed below.

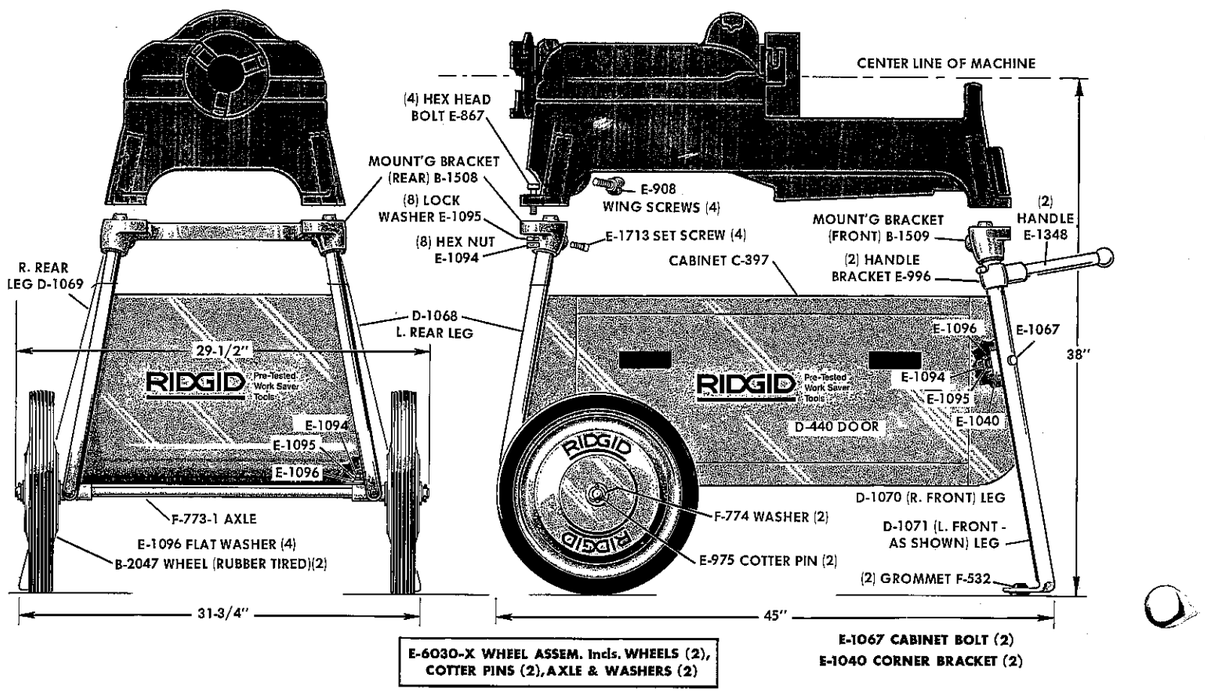


Assembling to RIDGID No. 8-R Enclosed Wheel Stand

1. Loosen four Set Screws (E-1713) in Mounting Brackets.
2. Set machine on Mounting Brackets (Front B-1509—Rear B-1508).
3. Attach machine Base to Mounting Brackets with four Hex Bolts (E-867).
4. Tighten four Set Screws (E-1713).

Bench Mounting

To mount the unit on a bench, use four ⅜" bolts in the holes provided at each corner of the machine Base. Base dimensions are shown in dimensional drawing (fig. 1).



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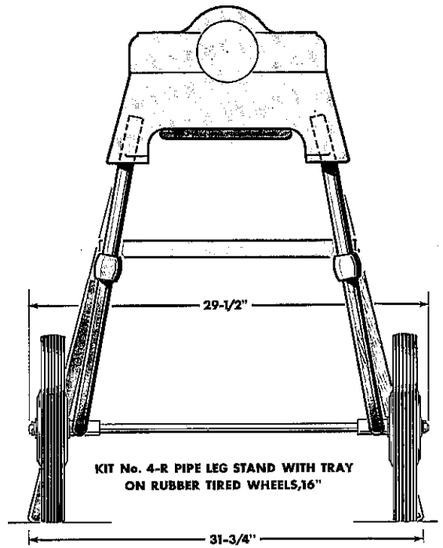
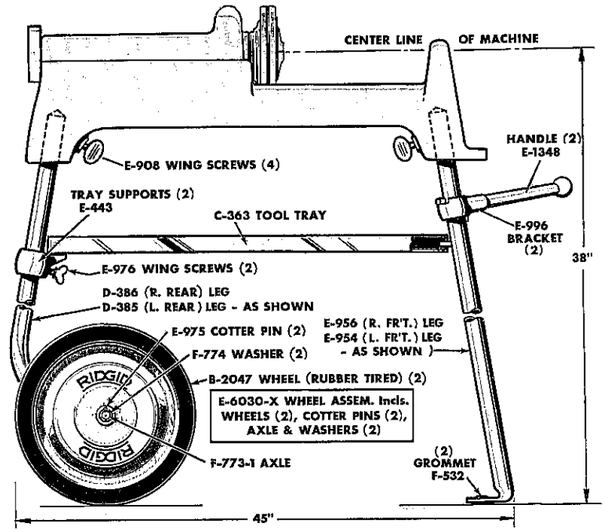
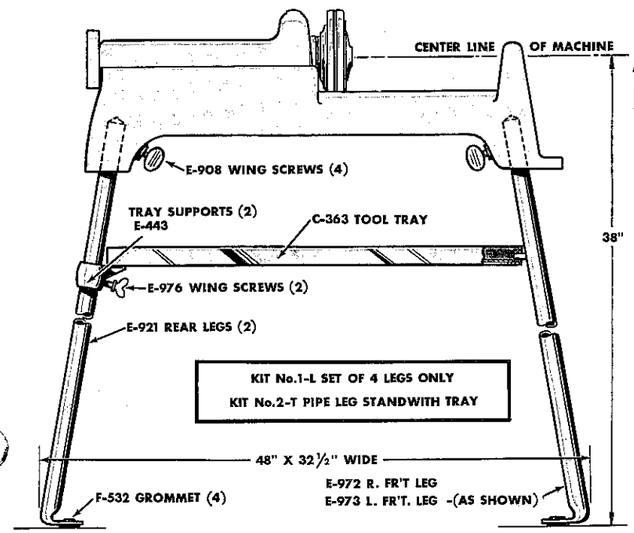




Assembling to RIDGID No. 4-R Open Wheel Stand

1. Insert Front Legs into machine base. Front Legs have small posts to support Tray (C-363). The lower posts must face toward the Rear Legs. Tighten Wing Screws (E-908).
2. Insert Rear Legs with the bends toward the front, making sure hubs are in a straight line for the axle. Tighten Wing Screws.
3. Slide axle thru both hubs, add Wheels, a Washer outside each Wheel, and Cotter Pins.
4. Insert Tray (C-363) by engaging holes on Front Leg posts as shown. Adjust the Supports (E-443) and slide up as far as possible. Tighten Wing Screws (E-976).
5. Screw Handles (E-1348) into Brackets (E-996).



Assembling to RIDGID No. 2-T Open Leg Stand (and No. 1-L Four Legs only)

1. Insert Legs into machine Base. Front Legs (E-972 Right—E-973 Left) have small posts which support Tray (C-363). These must face toward the Rear Legs.
2. The feet on Rear Legs (E-921) should toe in like the Front Legs. Tighten Wing Screws (E-908).
3. Insert Tray by engaging holes in Tray onto Front Leg posts as shown. Adjust Support (E-443) and slide up as far as possible. Tighten Wing Screw (E-976).

   Note: For self made legs—use 1" pipe—32½" long.

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Operating Instructions

1. Set up Machine on stand or bench.
2. Slide chip screen out of base.
3. Fill reservoir in base with approximately 5 quarts of RIDGID Thread Cutting Oil.
4. Plug power cord into outlet. Voltage of outlet must be the same as voltage indicated on tag and name plate.
5. Turn switch to "forward". If oil does not flow, prime pump.

To Prime Pump

Remove 3 screws on cover—lift off cover. The oil pump is located at right of the switch box. Remove screw plug in top of pump at "prime" mark. Fill pump with oil. FOR SAFETY—DO NOT RUN THE MACHINE WITH THE COVER OFF.

To Thread Pipe

1. Place die head into carriage. Set head to size.
2. Swing tools back to the "out-of-way" position. Insert pipe through chuck — front or rear.
3. Allow pipe to extend out of chuck to the desired length. Tighten Chuck — centering the work with the right hand. Make sure Chuck Wrench is removed before starting machine. If pipe extends out rear of machine, close rear centering jaws. For long lengths, support the end of the pipe with a RIDGID No. 92 Adjustable Pipe Support.
4. Swing the die head and the oil spout down, with the quick-opening lever set to the "close" position. Flip switch to "forward". Turn Carriage Handwheel to bring dies against end of pipe. Slight pressure on handwheel will starts dies.
5. A "standard thread" is cut when dies are flush with the end of the pipe. Flip quick-opening lever to "open" while machine is running. Turn Carriage Handwheel to back die head off.
6. Swing die head and oil spout back to "out-of-way" position.

To Thread Bolts

Follow above instructions. Cut desired length of thread. Open dies same as for pipe.

To Ream Pipe

1. Swing Reamer down in position and ream pipe by exerting pressure on handwheel. Reamer can be extended, if necessary, by pressing Reamer Latch and sliding Reamer Knob toward Reamer Arm until Latch engages Reamer Bar in extended position.

To Cut Off Pipe Or Rod

1. With reamer and die head out of way, bring No. 820 cutter down over pipe or rod. Turn cutter handle to cut. (⅛" to 2" pipe or ¼" to 1" rod).
2. For cutting off the larger sizes of rod, flow of oil can be directed to the cutter by pushing against end of spout and turning.

   To use length gage on machine carriage. Place cutter wheel against end of stock and set pointer to "0"—raise to clear stock and turn carriage handwheel until pointer is at length desired.

   No. 500 Pipe and Bolt Threading Machine cuts nipples and studs as short as 3½". To cut shorter nipples or studs, use RIDGID No. 819 Nipple Chuck. (See Page 9).

Cutting Pipe with No. 821 Blade-Type Cutter

1. Replace the No. 820 Cutter with the No. 821 Cutter. Chuck pipe as directed in chucking instructions, and with cutter, reamer and die head out of the way, operate Carriage Handwheel until cutter is over area of pipe to be cut. Operate Control Switch to FORWARD to rotate pipe. With Roll Housing on cutter retracted and Tool Holder Slide retracted against Stop Screw, bring cutter down to fit over pipe. Turn Locking Crank clockwise to force Rolls against pipe, direct Oil Spout toward Cutoff Tool, then turn Cutter Screw Crank Assembly clockwise to force Cutoff Tool against pipe to make cut. To chamfer, keep turning Cutter Screw Crank Assembly and apply counterclockwise pressure to Carriage Handwheel. (Applying pressure to Carriage Handwheel prevents chamfering tool from moving away.)
2. To make cutoff without getting oil inside the pipe, bring Oil Spout down just far enough to direct a small amount of oil onto the Wide Roll of the cutter. Shut off oil completely just before Cutoff Tool breaks through pipe.

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Maintenance and Repair

Note: Always unplug machine before servicing.

Lubrication

Proper lubrication is essential to trouble-free operation and long life of threading machine. Remove three Mounting Screws and remove the Cover from unit. Lubricate unit as follows:

1. Use grease gun to apply grease to the Shaft Bearing Grease Fittings every 2 to 6 months, depending upon amount of machine use.
2. Apply moderate coat of Lubricating Grease on Large Gear each time Bearings are lubricated.

WARNING: Do not operate the threading machine with Cover off. Always replace Cover immediately after lubricating machine.

Oil System Maintenance

To help assure proper operation of threading machine, keep oil system clean, as follows:

1. Replace Thread Cutting Oil when it becomes dirty or contaminated. To drain the Oil, position a container under Drain Plug and remove Plug.
2. Keep Oil Filter Screen clean to assure proper flow of clean Oil to work. Oil Filter Screen is located in the bottom of Oil Reservoir. To clean Filter Screen, loosen the screw that secures Filter to base and pull Filter from Oil Line. Clean Filter Screen in solvent and blow out with compressed air if available. Do not operate machine with Oil Filter Screen removed.

Motor Brush Replacement

Check Motor Brushes every 6 months and replace Brushes when they are worn to less than ½ inch. If Commutator is worn, turn O.D. of Commutator and undercut mica before replacing brushes.

Keep Jaw Serrations Clean

Use a wire brush to clean out grooves in Jaw Inserts. This should be done daily.

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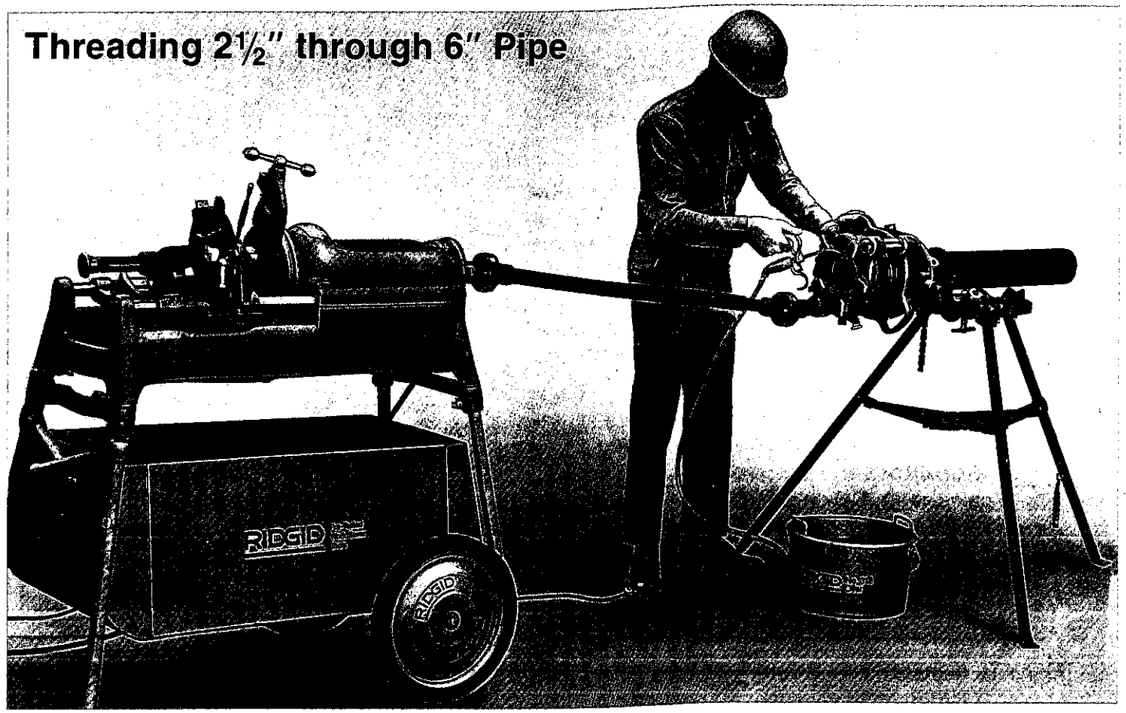


When threading pipe larger than 2" the No. 500 Machine must be securely bolted to the floor or to a bench.

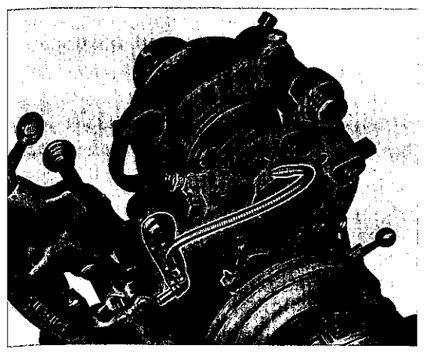
This operation requires a RIDGID Universal Drive Shaft, Foot Switch, and a Vise Stand capable of holding the size pipe desired. Anchor Vise Stand. Be sure it is in line, on the same level, and approximately the length of the Universal Drive Shaft away from the chuck of No. 500 Machine. Slide long hexagon end of Universal Drive Shaft into No. 500 Machine as illustrated above; tighten chuck and rear centering jaws. Place pipe securely in vise, slide geared threader on pipe and carefully center end of pipe in throats of dies. Slip square socket of Universal Drive Shaft over square end of pinion drive shaft of threader; tighten set screws. When properly positioned, sliding shank should neither be fully extended nor fully closed.

Plug 500 Machine cord into Foot Switch cord and then plug Foot Switch cord into grounded outlet. Put Machine switch in REV (reverse) position. Locate Foot Switch as shown above. To start 500 Machine use Foot Switch.

You are now ready to thread. Switch motor to reverse. During threading operation flood the dies with RIDGID Thread Cutting Oil (a high grade sulphur lard base oil).

No. 768 Drive Link Assembly

The RIDGID No. 768 Drive Link Assembly, together with No. 844 Drive Bar adapts No. 141 Threader to No. 500 Machine for threading 2½" through 4" pipe. Threader is supported by machine carriage and is driven directly by Drive Bar. No. 768 hooks threader to carriage to take threading torque. Pipe is gripped and rotated by threader workholder. If pipe extends beyond machine bed, it should be supported by Pipe Support.



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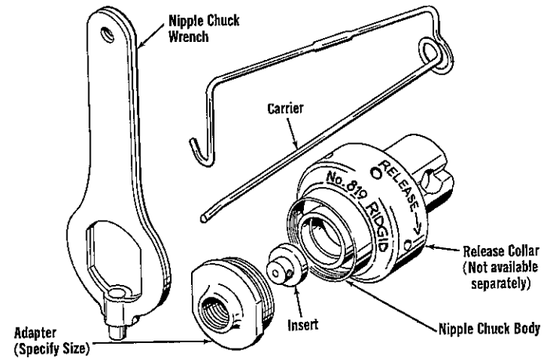
RIDGID No. 819 Nipple Chuck

The RIDGID Nipple Chuck, as shown, is a quick and easy tool for holding short and close nipples or studs for threading. For use with Pipe and Bolt Threading Machines, or RIDGID 200 and 300 Power Drives equipped with 2 Support Bars, No. 311 Carriage and Self-Opening and Quick-Opening Die Heads.

CAPACITY: ⅛" to 2" Standard Pipe (NPT).
¼" to 2" — Bolts or Studs. N.C. or N.F.

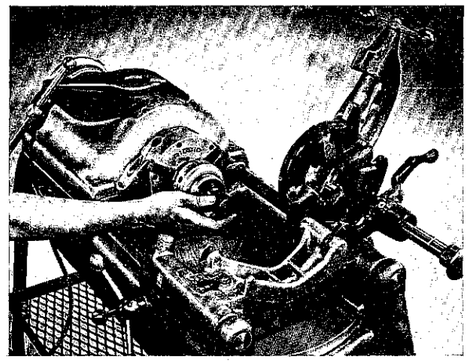
Pipe Adaptors	Stud Adaptors
⅛", ¼", ⅜", ½",	¼" to 2" U.N.C.
¾", 1", 1¼", 1½"	¼" to 1½" U.N.F.

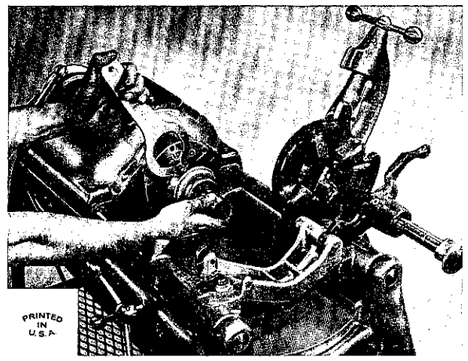


Nipple Chuck Body takes 2" pipe nipple. No separate adaptor required

To Thread a Short or Close Nipple

1. Grip a piece of pipe in machine chuck . . . thread and ream one end. Cut nipple to desired length.
2. Place RIDGID Nipple Chuck in machine chuck, gripping jaw grooves on sides of shank.
3. Turn Insert (see illustration) to the right size. ⅛" to ¾" sizes, small end toward adaptor . . . 1" size, large end toward adaptor. For 1¼" and up, insert is not used.
4. Select proper size Nipple chuck Adaptor and screw into nipple chuck by hand. Tighten with wrench. Screw half-threaded nipple into adaptor by hand and ream.
5. Bring Die Head into position and thread as before.
6. To release nipple, insert pin on end of wrench into one of the holes in Nipple Chuck Release Collar and turn as indicated. Remove threaded nipple by hand.





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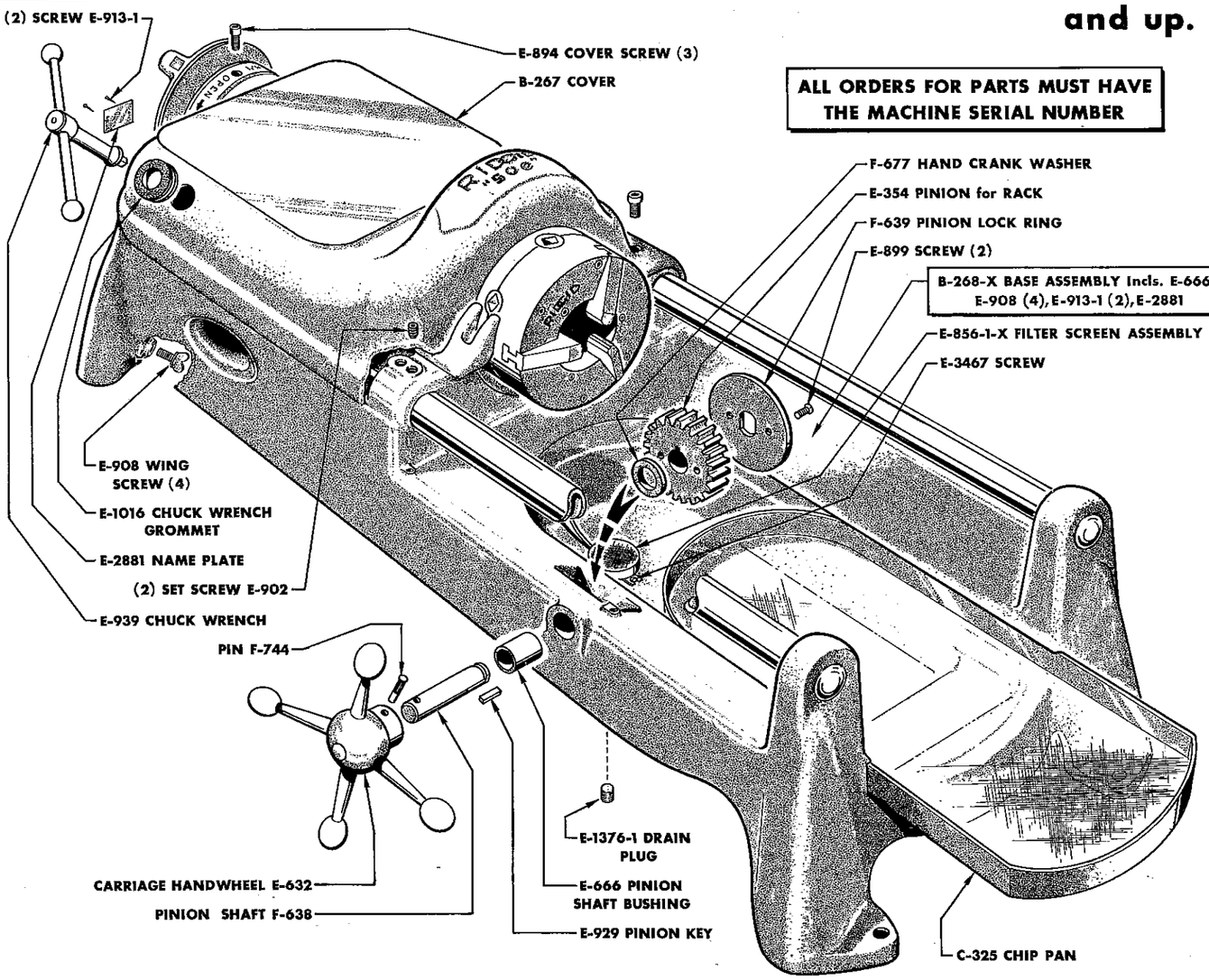
RIDGID BASE, COVER and HANDWHEEL for "500" MACHINE - Ser. No.1001 and up.



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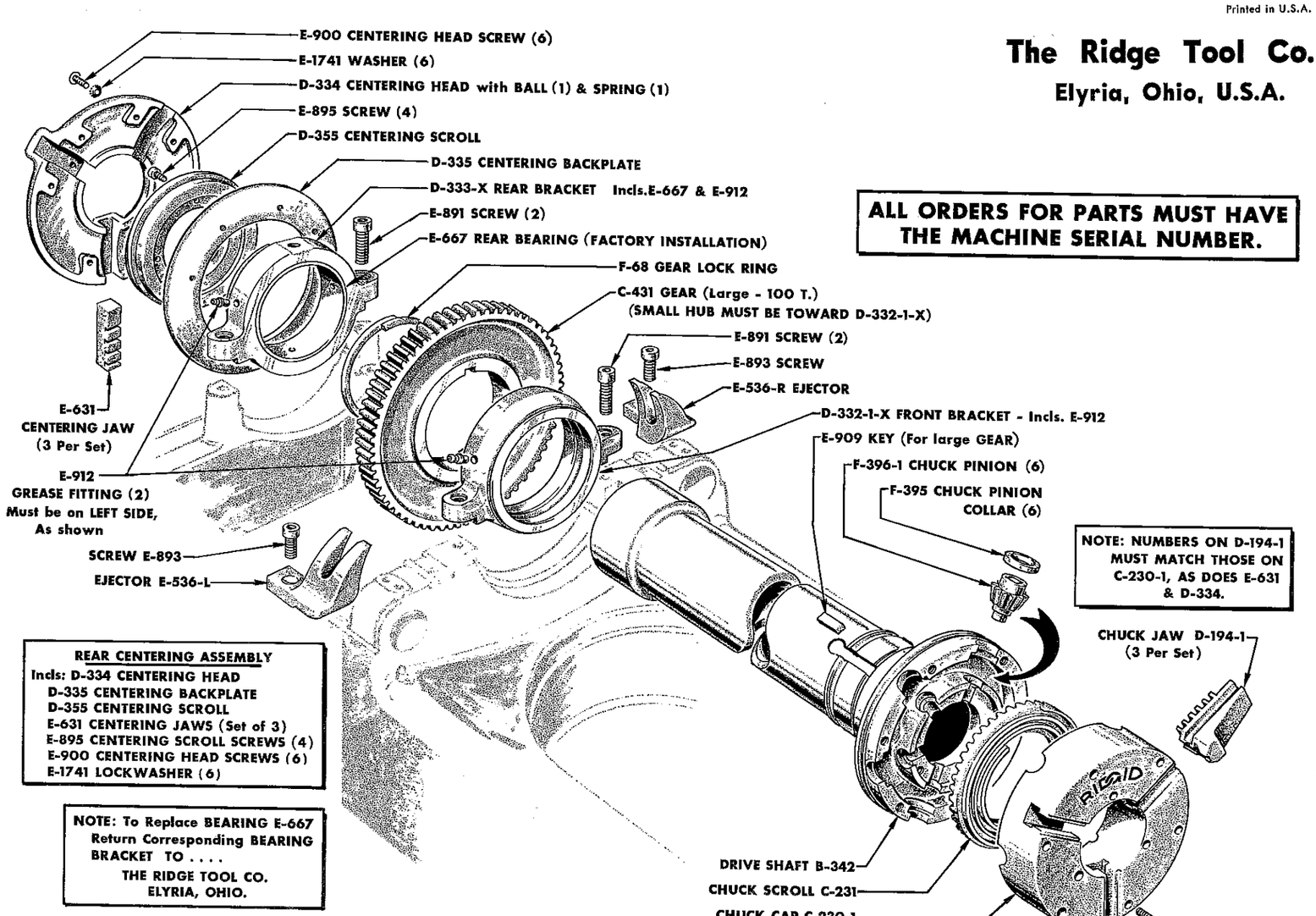


ALL ORDERS FOR PARTS MUST HAVE THE MACHINE SERIAL NUMBER.

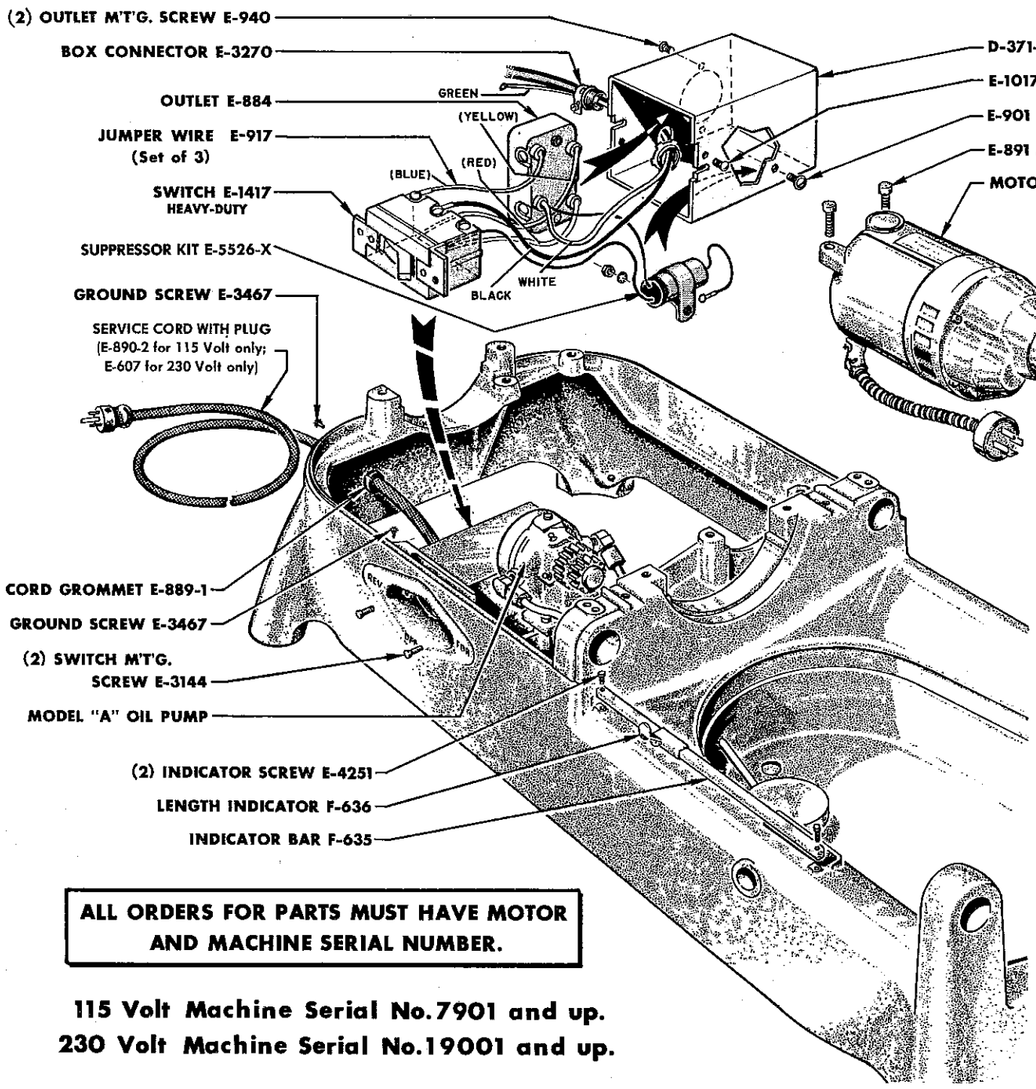
REAR CENTERING ASSEMBLY
Incls: D-334 CENTERING HEAD
D-335 CENTERING BACKPLATE
D-355 CENTERING SCROLL
E-631 CENTERING JAWS (Set of 3)
E-895 CENTERING SCROLL SCREWS (4)
E-900 CENTERING HEAD SCREWS (6)
E-1741 LOCKWASHER (6)

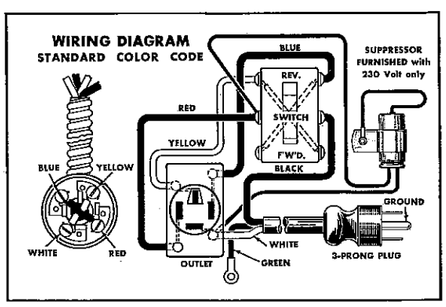
NOTE: To Replace BEARING E-667 Return Corresponding BEARING BRACKET TO . . . .
THE RIDGE TOOL CO.
ELYRIA, OHIO.

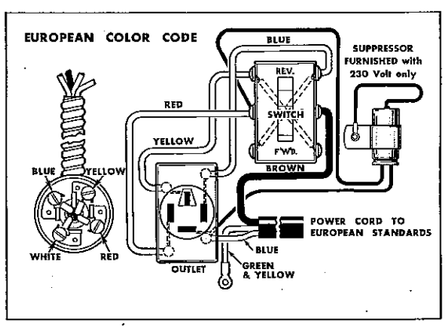
NOTE: NUMBERS ON D-194-1 MUST MATCH THOSE ON C-230-1, AS DOES E-631 & D-334.

RIDGID DRIVE SHAFT and CHUCK for "500" MACHINE · Serial No.5400 and up.

RIDGID Switch and Wiring Diagram.





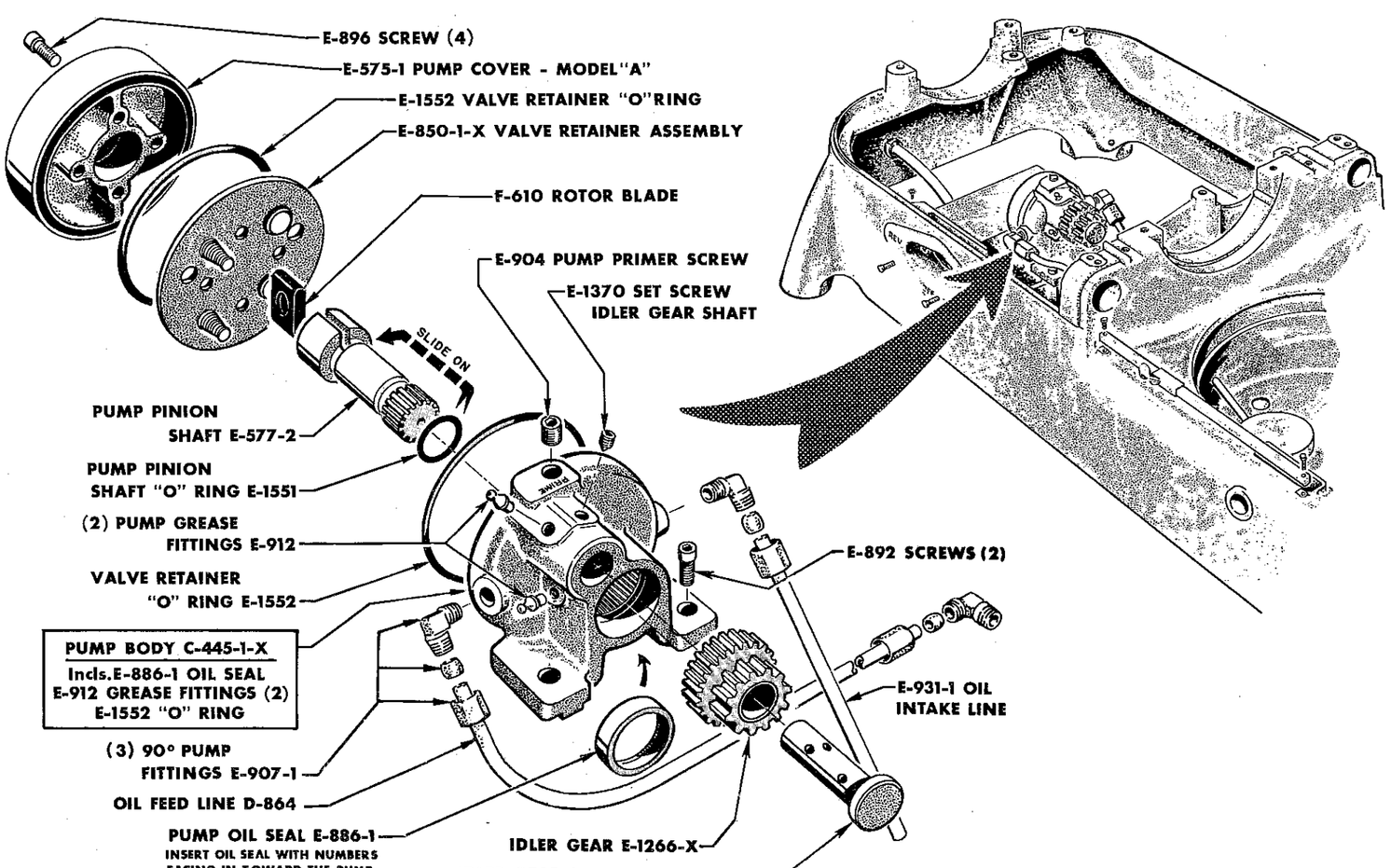


ALL ORDERS FOR PARTS MUST HAVE MOTOR AND MACHINE SERIAL NUMBER.

115 Volt Machine Serial No.7901 and up.
230 Volt Machine Serial No.19001 and up.

The Ridge Tool Company/Elyria, Ohio, U.S.A.
Printed in U.S.A.

RIDGID MODEL "A" PUMP for "500" MACHINES . . . 115 Volt Serial No.8,101 and up 230 Volt Serial No.19,101 and up



ALL ORDERS FOR PARTS MUST HAVE THE MACHINE SERIAL NUMBER

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Elyria, Ohio U.S.A.

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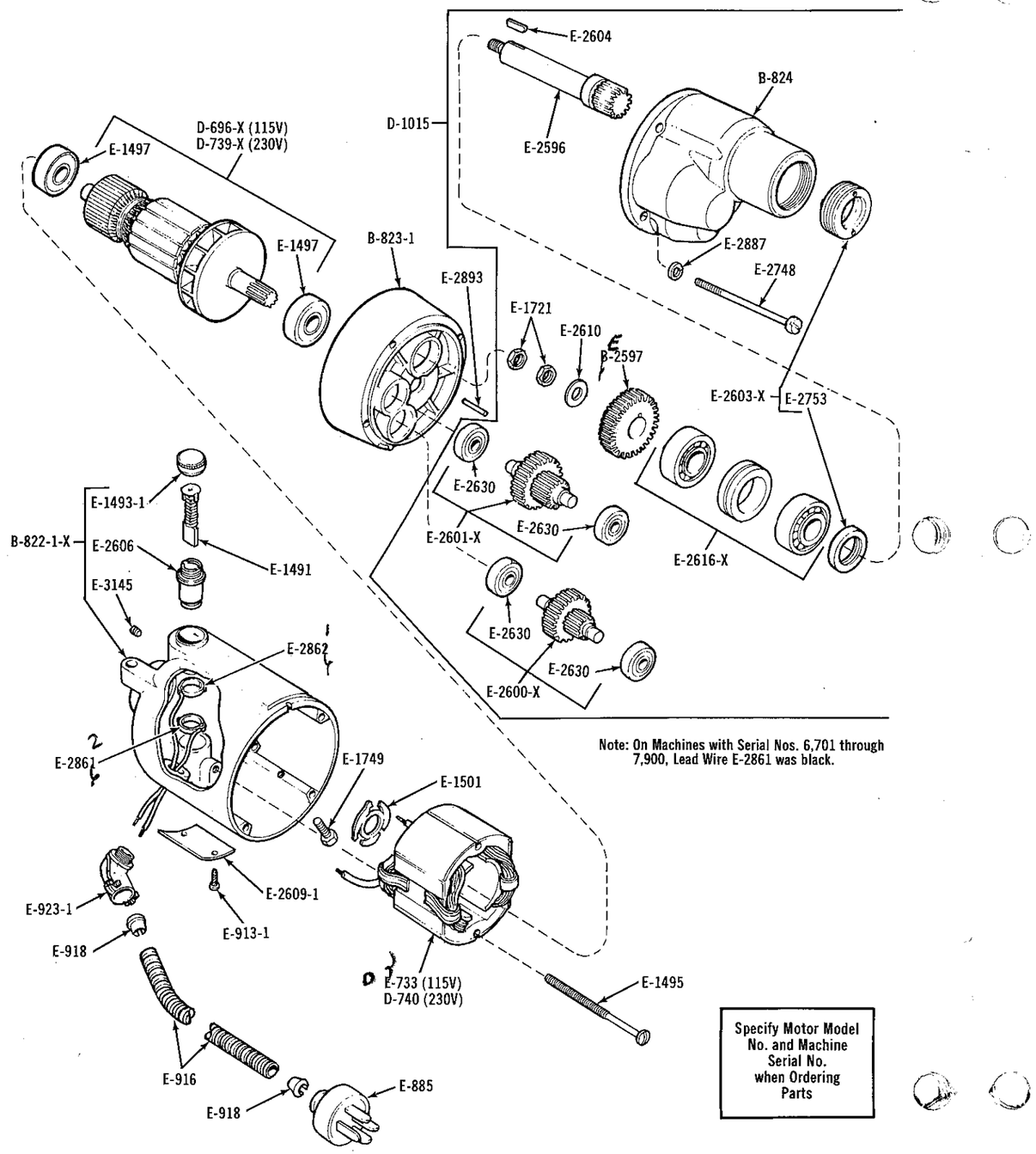
RIDGID Motors for 500 Machines

Model No. 1157 (115 Volt).
Model No. 2357 (230 Volt).



Note: On Machines with Serial Nos. 6,701 through 7,900, Lead Wire E-2861 was black.

Specify Motor Model No. and Machine Serial No. when Ordering Parts

The Ridge Tool Company/Elyria, Ohio, U.S.A.
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RIDGID Motors for 500 Machines

Model No. 1157 (115 Volt).
Model No. 2357 (230 Volt).

Part No.	Qty.	Part Name
B-822-1-X	1	Motor Housing Assembly (Incl. (2) E-1493-1, (2) E-2606 & (2) E-3145)
B-823-1	1	Fan Housing
B-824	1	Gear Housing
D-696-X	1	Armature and Fan Assembly (115 Volt) (Incl. (2) E-1497)
D-733	1	Field (115 Volt)
D-739-X	1	Armature and Fan Assembly (230 Volt) (Incl. (2) E-1497)
D-740	1	Field (230 Volt)
D-1015	1	Gear Head Assembly (Incl. B-824, E-1721, E-2596, E-2597, E-2600-X, E-2601-X, E-2603-X, E-2604, E-2610, E-2616-X)
E-885	1	4 Prong Plug
E-913-1	2	Drive Screw
E-916	1	Conduit
E-918	2	Insulator Bushing
E-923-1	1	45 Degree Connector
E-1491	2	Brush Assembly
E-1493-1	2	Brush Cap
E-1495	2	Field Mounting Screw
E-1497	2	Ball Bearings
E-1501	1	Loading Spring
E-1721	2	Main Drive Gear Locknut
E-1749	1	Locking Screw
E-2596	1	Main Drive Pinion (10 Tooth)
E-2597	1	Main Drive Gear (48 Tooth)
E-2600-X	1	1st Intermediate Gear Assembly (Incl. (2) E-2630)
E-2601-X	1	2nd Intermediate Gear Assembly (Incl. (2) E-2630)
E-2603-X	1	Lock Screw Assembly (Incl. E-2753)
E-2604	1	Main Drive Gear Key
E-2606	2	Brush Holder
E-2609-1	1	Name Plate
E-2610	1	Main Drive Gear Washer
E-2616-X	1	Roller Bearing Set (Incl. (2) Cone (2) Cup & Spacer)
E-2630	4	Ball Bearing
E-2748	4	Screw
E-2753	1	Oil Seal
E-2861	1	Upper Lead Wire and Connector (White)
E-2862	1	Lower Lead Wire and Connector (Red)
E-2887	4	Lock Washer
E-2893	1	Dowel Pin
E-3145	2	Set Screw

Specify Motor Model Number and Machine Serial Number when ordering parts.

Note: Motor Model No. 1157 (115 Volt) used with Machines Serial Nos. 6,701 through 7,800 and 7,901 and up.
Motor Model No. 2357 (230 Volt) used with Machines Serial Nos. 7,801 through 7,900 and 19,001 and up.

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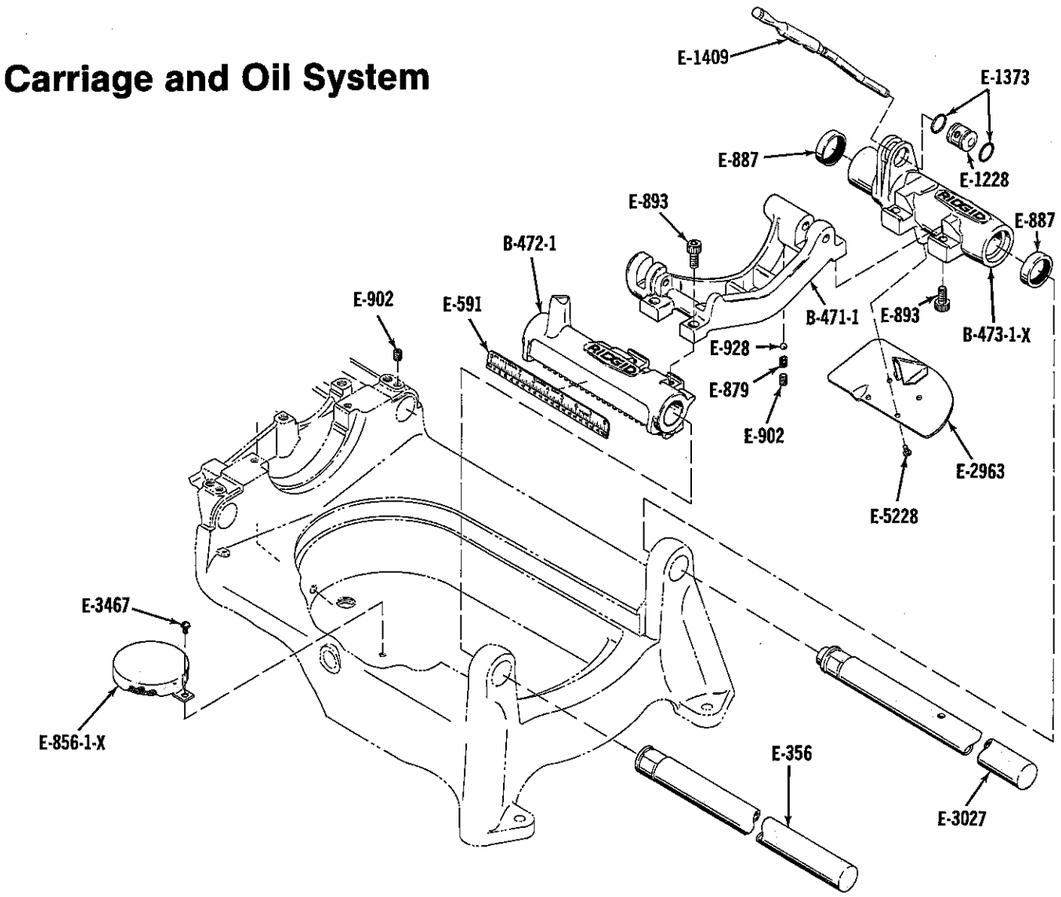
Carriage and Oil System



Part No.	Qty.	Part Name
B-471-1	1	Carriage
B-472-1	1	Carriage (Front) (Incl. E-591)
B-473-1-X	1	Carriage Support Assembly (Rear) (Incl. (2) E-887, E-2963, (4) E-5228)
E-356	1	Support Bar (Front)
E-591	1	Length Guage
E-856-1-X	1	Filter Screen Assembly
E-879	1	Spring (Carriage)
E-887	2	Oil Seal (Carriage Support)
E-893	4	Screw (Carriage Support)
E-902	1	Set Screw (Carriage)
E-928	1	Ball (Carriage)
E-1228	1	Shut Off Plug
E-1373	2	"O" Ring
E-1409	1	Oil Spout Assembly
E-2963	1	Oil Drip Plate
E-3027	1	Support Bar (Rear)
E-3467	1	Screw (Filter Screen)
E-5228	4	Drip Plate Mounting Screw

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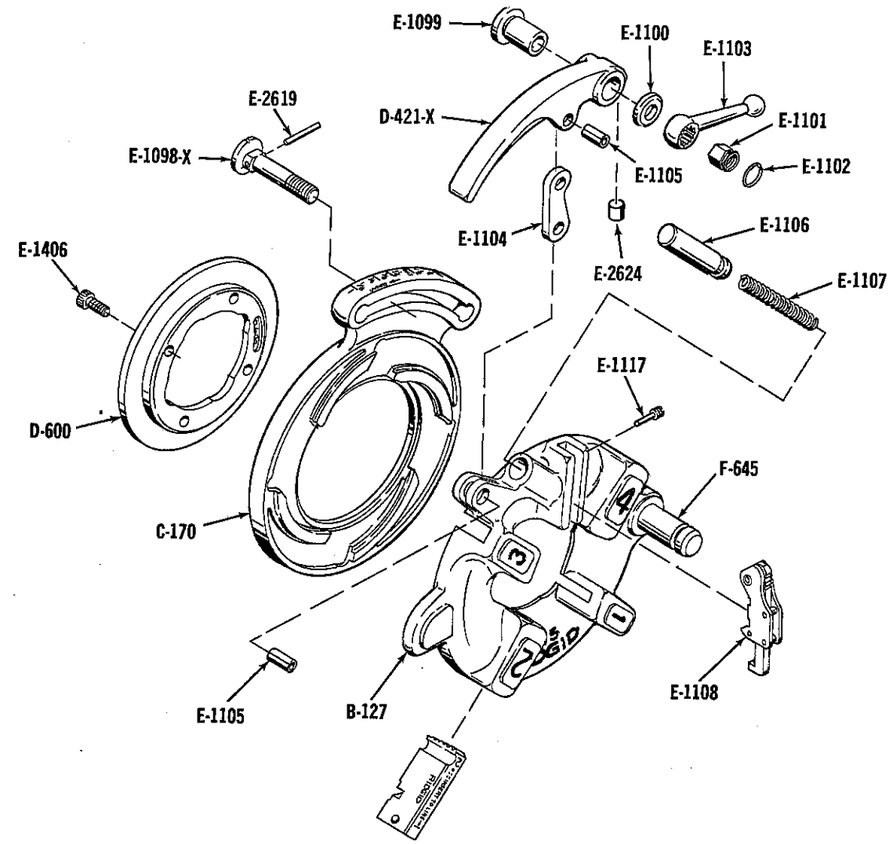
No. 815 Self-Opening Die Head



Part No.	Qty.	Part Name
B-127	1	Die Head with F-645 Post
C-170	1	Cam Plate
D-421-X	1	Throwout Lever with Insert
D-600	1	Retaining Ring
E-1098-X	1	Lock Screw (Includes E-2619)
E-1099	1	Bushing For Lock Screw
E-1100	1	Washer
E-1101	1	Hex Nut
E-1102	1	Retaining Spring Ring
E-1103	1	Clamp Lever
E-1104	1	Throwout Link
E-1105	2	Roll Pin
E-1106	1	Throwout Plunger
E-1107	1	Compression Spring for Plunger
E-1108	1	Trigger Assembly
E-1117	1	Screw for Trigger Assembly
E-1406	4	Screw for Retaining Ring
E-2619	1	Pin
E-2624	1	Insert
F-645	1	Post

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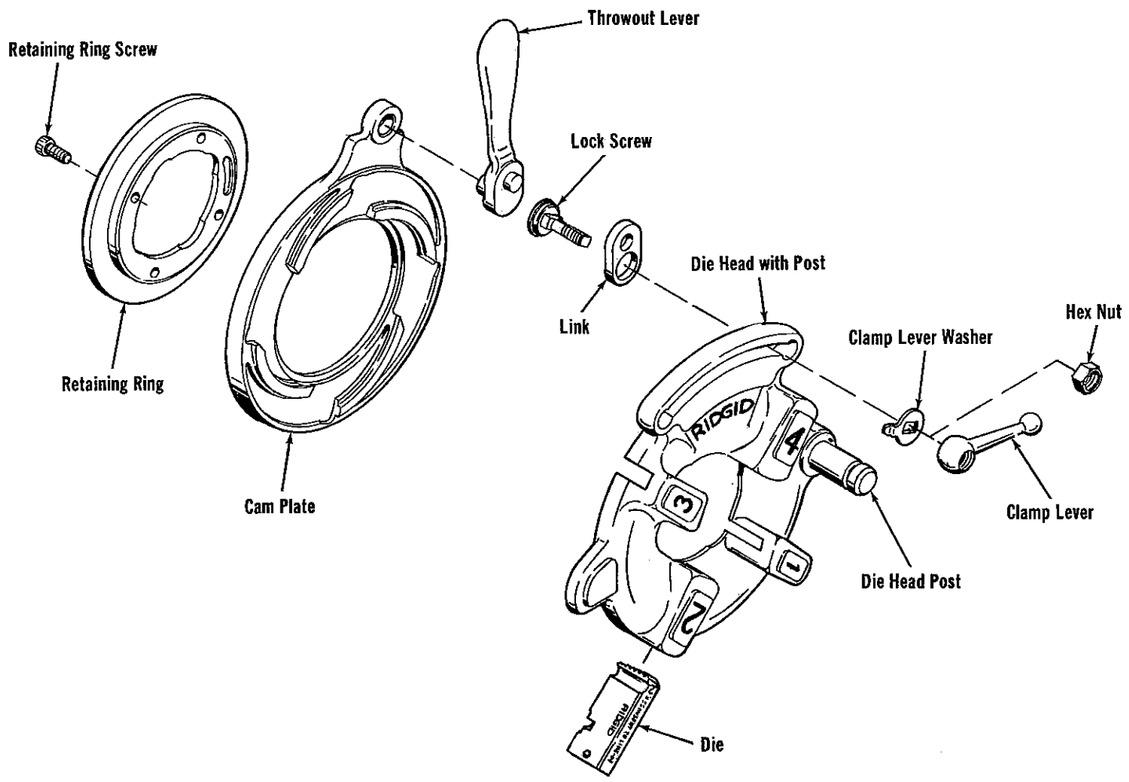
Die Heads - Universal, No. 515, No. 514, Mono and No. 500-B



Die Heads - Universal, No. 515, No. 514, Mono and No. 500-B

RIDGID No. 500 Pipe and Bolt Threading Machine

Die Head	Cam Plate	Clamp Lever	Clamp Lever Washer	Die Head (RH) With Post	Die Head (LH) With Post	Die Head Post	Hex Nut	Link	Lock Screw	Retaining Ring (RH)	Retaining Ring (LH)	Retaining Ring Screw	Throwout Lever
Universal Die Head	C-329	F-672	E-1042	B-728	B-835	F-645	—	F-536	E-933	D-600	D-663	E-1406	E-660
	Pipe Die Sets (RH) 1/8", (1/4" and 3/8"), (1/2" and 3/4"), (1" thru 2"). (LH) (1/4" and 3/8"), (1/2" and 3/4"), (1" thru 2").												
	Bolt Die Sets (RH) UNC or UNF 1/4", 5/16", 3/8", 7/16", 1/2", 9/16", 5/8", 3/4", 7/8", 1", 1 1/8", 1 1/4", 1 3/8", 1 1/2", Universal (RH) UNC 1 3/4", 2". (LH) None.												
No. 515 (RH)	C-332	F-672	E-1042	B-297-1	—	F-645	—	F-536	E-933	E-612	—	E-1406	E-671
	Pipe Die Sets (RH) No. 551 — 1/8", No. 552 — (1/4" and 3/8"), No. 554 — (1/2" and 3/4").												
No. 514 (LH)	C-332	F-672	E-1042	—	B-1120	F-645	—	F-536	E-933	—	E-612	E-1406	E-671
	Pipe Die Sets (LH) 1/8", (1/4" and 3/8"), (1/2" and 3/4").												
Mono Die Heads (RH) 1/8"	C-244	—	E-1042	B-312	—	F-645	E-905	F-536	F-663	E-367	—	E-1406	E-671
1/4", 3/8"	Pipe Die Sets 1/8", 1/4", 3/8".												
RH or LH	C-242	—	E-1042	B-309	B-422	F-645	E-905	F-536	F-663	E-366	E-1118	E-1406	E-671
1/2", 3/4"	Pipe Die Sets 1/2", 3/4" (RH or LH).												
RH or LH	C-240	—	E-1042	B-307	B-450	F-645	E-905	F-536	F-663	E-365	E-1144	E-1406	E-671
1", 1 1/4"	Pipe Die Sets 1", 1 1/4" (RH or LH).												
RH or LH	C-239	—	E-1042	B-308	B-453	F-645	E-905	F-536	F-663	E-351	E-1146	E-1406	E-671
1 1/2", 2"	Pipe Die Sets 1 1/2", 2" (RH or LH).												
No. 500-B Bolt Die Heads RH or LH	C-383	F-672	E-1042	B-359	B-359	F-645	—	F-536	F-537	E-839	E-839	E-1406	E-671
1/4" thru 1"	Bolt Die Sets 1/4", 5/16", 3/8", 7/16", 1/2", 9/16", 5/8", 3/4", 7/8", 1" UNC or UNF Right Hand or Left Hand.												
RH or LH	C-384	F-672	E-1042	B-360	B-360	F-645	—	F-536	F-537	E-840	E-840	E-1406	E-671
1 1/8" thru 2"	Bolt Die Sets 1 1/8", 1 1/4", 1 3/8", 1 1/2" UNC or UNF, 1 3/4", 2" UNC Right Hand or Left Hand.												
	8 UN — 1 1/8" thru 2 1/2"; 12 UN — 1/2" thru 2 1/2"; 16 UN — 13/16" thru 2 1/2".												
	General Purpose Acme and Metric Dies Available on Request.												

The Ridge Tool Company/Elyria, Ohio, U.S.A.
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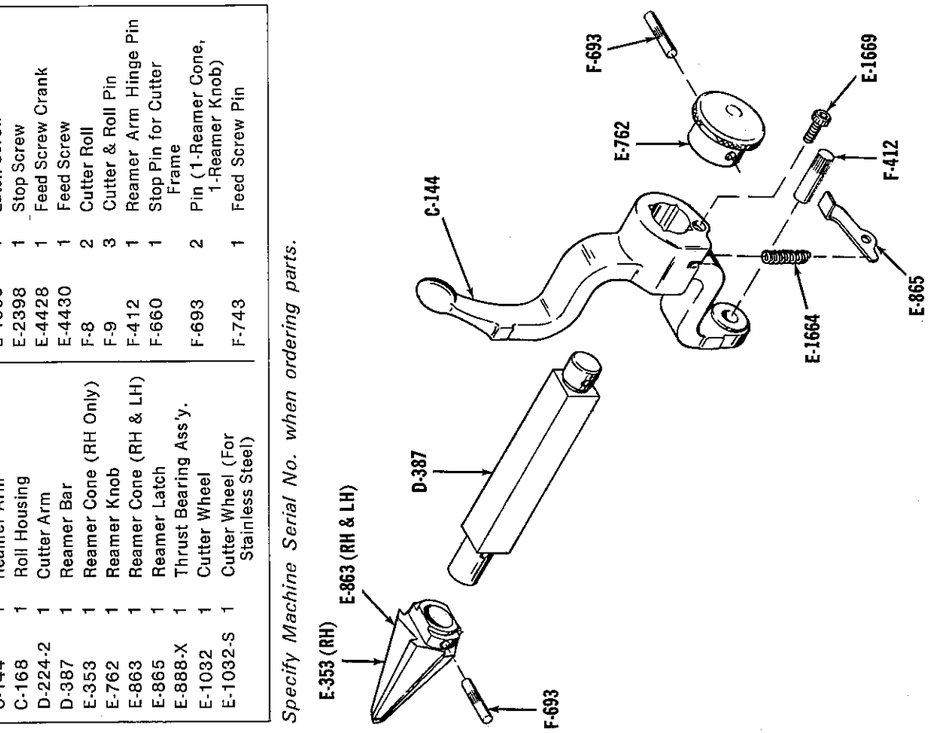
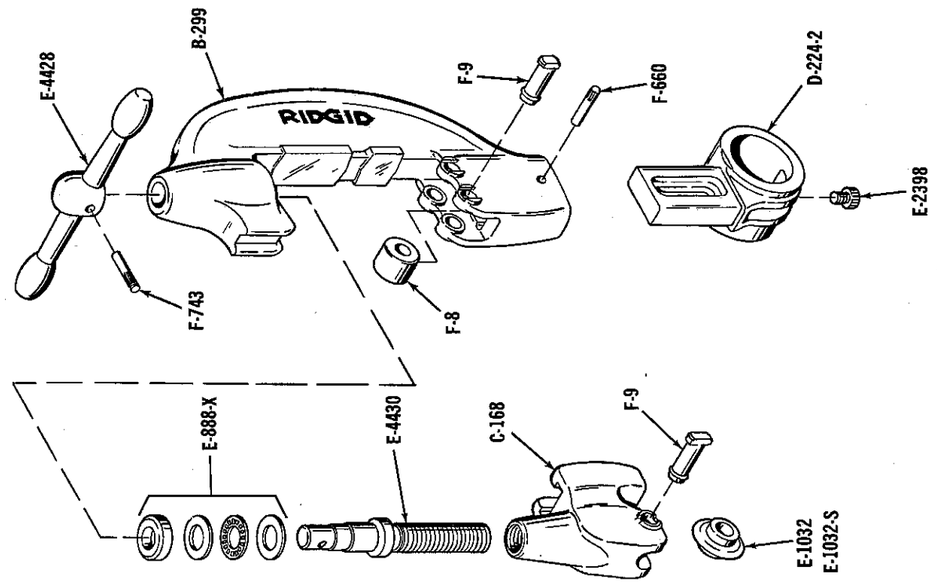
No. 820 Cutter and No. 341 Reamer

Part No.	Qty.	Part Name
B-299	1	Cutter Frame
C-144	1	Reamer Arm
C-168	1	Roll Housing
D-224-2	1	Cutter Arm
D-387	1	Reamer Bar
E-353	1	Reamer Cone (RH Only)
E-762	1	Reamer Knob
E-863	1	Reamer Cone (RH & LH)
E-865	1	Reamer Latch
E-888-X	1	Thrust Bearing Ass'y.
E-1032	1	Cutter Wheel
E-1032-S	1	Cutter Wheel (For Stainless Steel)
E-1664	1	Latch Spring
E-1669	1	Latch Screw
E-2398	1	Stop Screw
E-4428	1	Feed Screw Crank
E-4430	1	Feed Screw
F-8	2	Cutter Roll
F-9	3	Cutter & Roll Pin
F-412	1	Reamer Arm Hinge Pin
F-660	1	Stop Pin for Cutter Frame
F-693	2	Pin (1-Reamer Cone, 1-Reamer Knob)
F-743	1	Feed Screw Pin

Specify Machine Serial No. when ordering parts.





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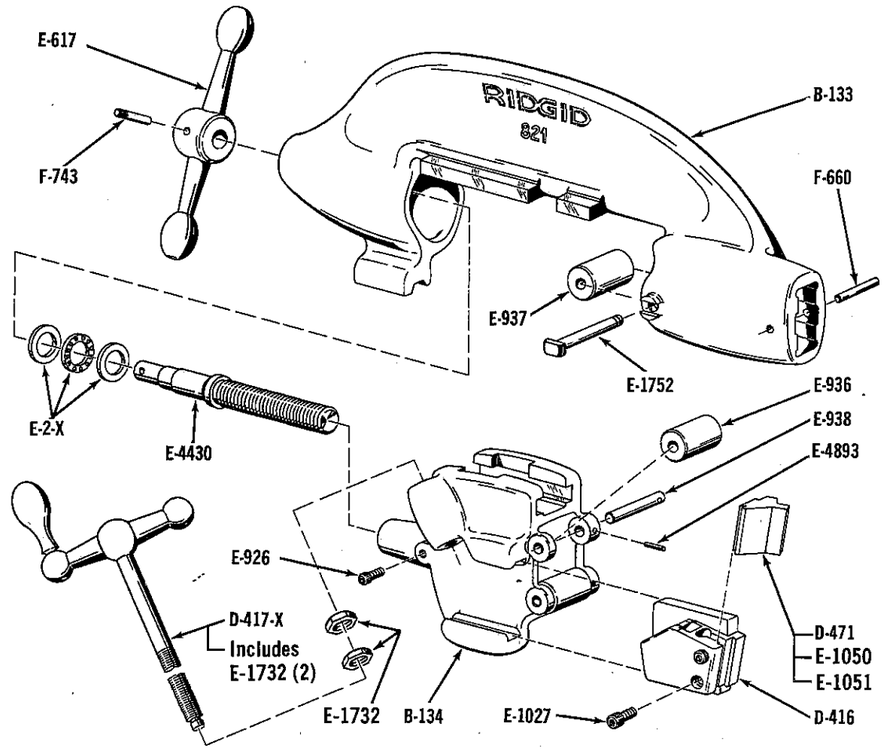
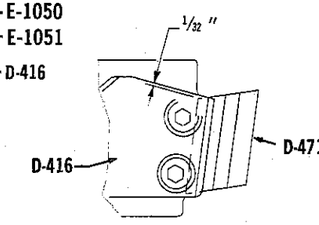
No. 821 Blade-Type Cutter





Note: Tool Bits should be 1/32" below surface as shown for proper cutting.

Part No.	Qty.	Part Name	Part No.	Qty.	Part Name
D-417-X	1	Cutter Screw Assembly (Incl: (2) E-1732)	E-937	1	Wide Roll
			E-938	2	Narrow Roll Pin
E-2-X	1	Bearing Assembly	E-1027	2	Screw
B-133	1	Cutter Frame	*E-1050	1	Tool Bit
B-134	1	Roll Housing	*E-1051	1	Tool Bit
D-416	1	Tool Holder Slide	E-1732	2	Hex. Nut
D-471	1	Cutoff Tool	E-1752	1	Wide Roll Pin
E-507	1	Allen Wrench	E-4430	1	Feed Screw
E-617	1	Locking Crank	E-4893	2	Spring Pin
E-926	1	Stop Screw	F-660	1	Stop Pin
E-936	2	Narrow Roll	F-743	1	Crank Pin

*Denotes Tool Bit for special application

The Ridge Tool Company/Elyria, Ohio, U.S.A.
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Availability of Dies and Threaders

Die Head or Threader			Pipe					Bolt														
			For All NPT — NPSM — BSPT and BSPP				British Electrical Conduit (BEC)	For All UNC — UNF — BSW and BSF				Constant Pitch Series 8UN,12UN 16UN		General Purpose ACME		Metric (S.I.) Series "A"			Metric (S.I.) Series "B"			Metric Trapezoidal
			Alloy		High Speed		Alloy	Alloy		High Speed		High Speed		High Speed		Alloy	High Speed		Alloy	High Speed		High Speed
Model Number	Range																					
	Pipe	Bolt	R.H.	L.H.	R.H.	L.H.	R.H.	R.H.	L.H.	R.H.	L.H.	R.H.	L.H.	R.H.	L.H.	R.H.	R.H.	L.H.	R.H.	R.H.	L.H.	R.H. or L.H.
No. 815 (R.H.) (1)	1/8"-2"	1/4"-2"			X		X			X												
Universal (R.H.) (1)	1/8"-2"	1/4"-2"	X		X		X	X		X												
Universal (L.H.) (1)	1/4"-2"			X		X																500-B
515 (R.H.)	1/8"-3/4"		X		X																	Head
514 (L.H.)	1/8"-3/4"			X		X																Only
Mono (R.H.)	1/8"-2"		X		X																	
Mono (L.H.)	1/2"-2"			X		X																Write
0-R (1)	1/8"-1"		X	X	X	X																for
00-R (1)	1/8"-1"		X	X	X	X																Prices
11-R (1)	1/8"-1 1/4"		X	X	X	X																and
111-R (1)	1/8"-1 1/4"		X	X	X	X																Delivery
12-R (1)	1/8"-2"		X	X	X	X																
30-A (1)	3/8"-3/4"		X	X	X	X																
31-A (1)	1/2"-1"		X	X	X	X																
65-R (1,2,5)	1"-2"				X																	
4PJ (1,2,3)	2 1/2"-4"		X		X																	
141 (1,2)	2 1/2"-4"				X																	
161 (1,2)	4"-6"				X																	
502	1/2"-3/4"		X		X																	
504	1"-2"		X		X																	
101		1/4"-1"						X	X	X	X	X		X	X							
500-B (1/4"-1")		1/4"-1"						X	X	X	X	X										
500-B (1 1/8"-2")		1 1/8"-2"						X	X	X	X	X										
00-RB (4)		1/4"-1"						X	X													
11-R	1/2"-1 1/2" (6)						X															
500-B (1/4"-1")	1/2"-1" (6)																					
500-B (1 1/8"-2")	1 1/4"-2" (6)																					
500-B (1/4"-1")		3/8"-5/8"												X	X							
500-B (1 1/8"-2")		3/4"-2"												X	X							
101		6mm-25mm														X	X	X	X		X	
500-B (1/4"-1")		6mm-25mm														X	X	X	X		X	
500-B (1 1/8"-2")		26mm-35mm														X	X	X	X		X	
500-B (1 1/8"-2")		36mm-52mm															X	X		X	X	

Footnotes:
(1) Requires British Threader to cut British Threads
(2) Cuts Right Hand Threads only
(3) Requires Special Threader for Parallel Threads (NPSM or BSPP)
(4) BSF not Available
(5) Not recommended for NPSM or BSPP
(6) Nominal Diameters are actual OD's in inches

Explanation of Thread Forms:

NPT		National Pipe Taper
NPSM		National Pipe Straight Mechanical
BSPT		British Standard Pipe Taper
BSPP		British Standard Pipe Parallel
UNC	(NC)	Unified National Coarse
UNF	(NF)	Unified National Fine
BSW		British Standard Whitworth
BSF		British Standard Fine
BEC		British Electrical Conduit

The Ridge Tool Company/Elyria, Ohio, U.S.A.
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RIDGID

Pre-Tested Work Saver Tools

Guarantee

All RIDGID Machines, Power Drives, and Hand Tools are guaranteed against defects in workmanship and material. This guarantee covers all RIDGID products except electric motors, which are guaranteed for six months from date of sale. NO OTHER GUARANTEE, WRITTEN OR ORAL, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, APPLIES. No employee, agent, dealer, or other person is authorized to give any guarantees on behalf of The Ridge Tool Company. Claims cannot be allowed until the questioned product has been received, freight prepaid, at our factory. Defective products will be repaired or replaced, at our option, at no charge to you. Such replacement or repair is the exclusive remedy available from Ridge. Ridge is not liable for damage of any sort, including incidental and consequential damages.

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